

~~OLD STYLE~~

Date: Tuesday, 15/08/2006 7:17:12 AM
User: Linda Lacelle

Process Sheet

split 06/09/07

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BRACKET ASSEMBLY
Job Number	: 28159		
Estimate Number	: 11033		
P.O. Number	: N/A	Part Number	: D2803044
This Issue	: 15/08/2006	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D2803 REV B
First Issue	: N/A	Project Number	: N/A
Previous Run	: N/A	Drawing Revision	: B
		Material	: N/A
Written By	: _____	Due Date	: 08/09/2006
Checked & Approved By	: _____	Qty:	8 Um: Each
Comment	: Est D 05.03.30 MS21043-3 was MS21042L3	KJ/JLM	

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D28032 STA 84 Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)
STA 84 BRACKET

Pick:

Qty Part Number Description
1 D2803-2 5 Bracket

Batch

B27604 3MCP

+

AP 06/08/31

2.0 D28054 Stop



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)
STOP

Pick:

Qty Part Number Description
1 D2805-4 4 Stop

Batch

B27617 108

B28183

AP 06/08/31

3.0 D2809 Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)
Bushing

Pick:

Qty Part Number Description
1 D2809 Bushing

Batch

B27617 108

Press D2805-4 into arm as per Dwg D2803

MF. 06/09/18

8

AP 06/08/31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 15/06/2006 7:17:12 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 28159

Part Number: D2803044

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

QC5

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SB 06/09/18 8

5.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

FC 06/09/18 (P)

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

MF 06/09/18 (P)

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Press D2809 into arm as per Dwg D2803

MF 06/09/18 (8)

8.0

AN3C16A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 16.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description	Batch
2	AN3C16A	Bolt	170189 ✓

170189 ✓

18/06/08/31

9.0

MS210433

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total: 16.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description	Batch
2	MS21043-3	Nut	1719099 ✓

1719099 ✓

18/06/08/31

10.0 (G)

NAS1515H3

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 32.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch
4	NAS1515H3	Washer	17100993
A/R	LPS-3	Corrosion Spray	17101472

17100993

17101472

MF

06/09/18

18/06/08/31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06/09/18	106	Put LPS Handcoat Corrosion Inhibitor on each washer. <u>M17045</u>	MF. 8/6	06/09/18. (8) 0609.19			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: PE Date: 06/09/19
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 15/06/2006 7:17:12 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 28159

Part Number: D2803044

Job Number:



Seq. #:

Machine Or Operation:

Description :

Spray LPS-3 on Bolt Shaft, not on thread as per Dwg D2803

M101472

mf. 06/09/18

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Assemble as per Dwg D2803.

mf. 06/09/18

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 06/09/19

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: GA

ST161

SB 06/09/19 ①

SB 06/09/18

14.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

SB 06/09/19

Job Completion



h 06/09/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

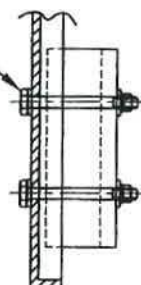
NOTE: Date & initial all entries



DESIGN [Signature]	DRAWN BY [Signature]	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED [Signature]	DRAWING NO. D2803	REV. A SHEET 2 OF 2
DATE 00.11.07	TITLE STA 84 BRACKET		SCALE 1:3

RELEASED
00.11.13

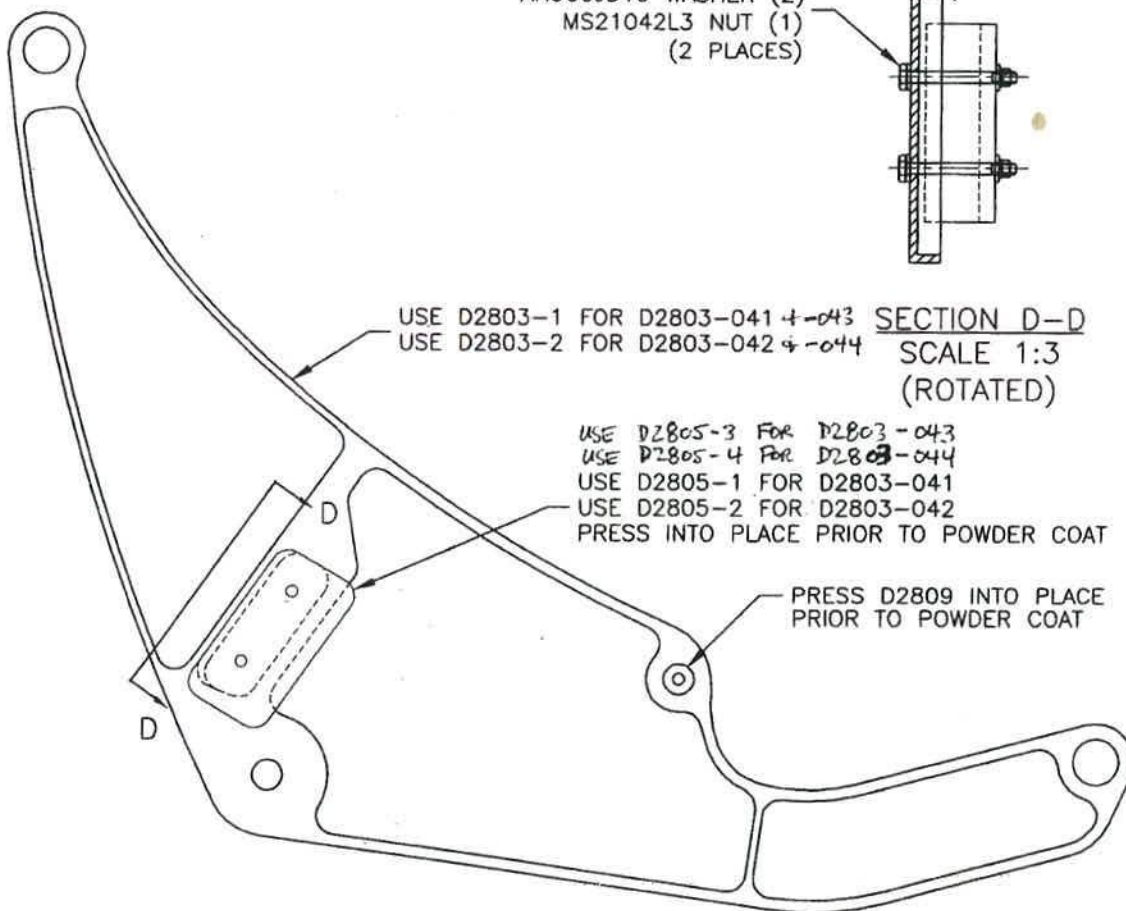
AN3-16A BOLT (1)
AN960JD10 WASHER (2)
MS21042L3 NUT (1)
(2 PLACES)



USE D2803-1 FOR D2803-041 + -043
USE D2803-2 FOR D2803-042 + -044
SECTION D-D
SCALE 1:3
(ROTATED)

USE D2805-3 FOR D2803-043
USE D2805-4 FOR D2803-044
USE D2805-1 FOR D2803-041
USE D2805-2 FOR D2803-042
PRESS INTO PLACE PRIOR TO POWDER COAT

PRESS D2809 INTO PLACE
PRIOR TO POWDER COAT



D2803-041 ASSEMBLY (SHOWN) → D2803-043 SIMILAR
D2803-042 ASSEMBLY (OPPOSITE) → D2803-044 SIMILAR

FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY
SANDTEX (4.3.5.6) OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX
(4.3.5.8) PER DART QSI 005 4.3

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